

Work Order ID 82107

82107

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March-22-12 3:35:35 PM

Item ID: D205-523-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli Rappel, 500lb
 Start Date: 22/03/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9301	Rev A								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy blue file & type labels as per PPP D205-523-013, CHG 002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

Handwritten: J. Ver MLJ 12-5-17 (2)

Handwritten: 12548

Handwritten: S. 12/03/12

Handwritten: (72)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D205-523-013	Identify and							
	Stock Location: <u>22</u>								
	<u>Rec'd</u>								
140		0.00							
140	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

MF
12-05-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 82107

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Parent Item: D205-523-013

D205-523-013

Parent Item Name: Heli Rappel, 500lb

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP B02.04.04 Updated Drawing and Added Inspection Level 21SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D205-523-043

Manufactured

No

110

Each

2.0000

0

2

D205-523-043

Slide Bar Assembly

**

Location

Loc Qty

Loc Code

ST187

2

79706

2

D2224

Manufactured

No

110

Each

0.0000

0

2

D2224

Rappel Anchor

**

D2229

Manufactured

No

110

Each

14.0000

2

4

D2229

Doubler

**

Location

Loc Qty

Loc Code

ST006

14

55316

14

AN5-14A

Purchased

No

110

Each

40.0000

4

8

AN5-14A

Bolt

**

Location

Loc Qty

Loc Code

ST338

40

119127

15

120360

25

1/2 5/8

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Wbrk Order ID: 82107

Parent Item: D205-523-013

Parent Item Name: Heli Rappel, 500lb

82107

D205-523-013

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 2.00

Required Qty: 2.00

MS21042L5

Purchased

No

110

Each

1,578.000

4 8

**

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1578

116105

5

116548

43

117611

42

119109

1488

110

Each

0.0000

AN960JD516

NAS1149D0563J

Purchased

No

AN960JD516

Washer

**

8 16

MI971

MI18614

2x

MI18106

4x

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>CP</i>	DRAWING NO. DSI 9301	REV. A SHEET 1 OF 1
DATE 05.05.11		TITLE RAPPEL ANCHOR INSTALLATION	SCALE NTS
A	05.05.11	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D205-523 REV. F

REF. CANADIAN STC: SH96-90 ISSUE 3

REF. FAA STC: SR00511NY, SR00512NY, SR00513NY

It has come to DART's attention that in general, AN5-13A bolts are a more suitable length for installation of the D2224 Rappel Anchor (ref) in place of the AN5-14A bolts referred to in D205-523 Rev.F.

It is acceptable to install the D2224 Rappel Anchor (ref) using longer or shorter AN5 bolts as needed to suit the thickness of the rotorcraft's ceiling panel. It is acceptable to use a light AN960JD516L washer under the head of the bolt instead of an AN960JD516 washer per D205-523 Rev. F. However, to preserve the structural integrity of the system, the washer under the MS21042L5 nut must remain an AN960JD516 washer.

For all cases, ensure the bolts properly secure the D2224 Rappel Anchor (ref) to the rotorcraft's ceiling and each bolt has at least 2 threads in safety.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 82157 MJS
12/03/22

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: <i>D. Shepherd</i>	D. SHEPHERD (DE # 02)
DATE: <u>05.05.11</u>	
CERT. NO.: <u>SH96-90</u>	
ISSUE NO.: <u>3</u>	

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REFERENCE ONLY**25.4 WEIGHT AND BALANCE**

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-523-013	3.5 lb 1.59 kg	±34.5 in ±0.876 m	±120.75 in-lb ±1.39 m-kg	116.8 in 2.97 m	408.8 in-lb 4.72 m-kg

25.5 PARTS LIST

-013	-023	-043	Part No.	Description
X			D205-523-013	HELI-RAPPEL™ INSTALLATION
	X		D205-523-023	300 HOUR INSPECTION KIT
1		X	D205-523-043 /	SLIDE BAR ASSEMBLY
		1	D3011-1	RAPPEL SLIDE BAR
		2	33116	STUD FITTING
	2	2	MS21042L6	NUT (OR MS21042-6)
	2	2	AN960JD616	WASHER
	2	2	D3012-1	DECAL
	2	2	D3012-3	DECAL
	2	2	D3012-5	DECAL
1			D2224	RAPPEL ANCHOR
2			D2229	DOUBLER
4	4		AN5-14A	BOLT
8	8		AN960JD516	WASHER
4	4		MS21042L5	NUT (OR MS21042-5)

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